

66863678

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



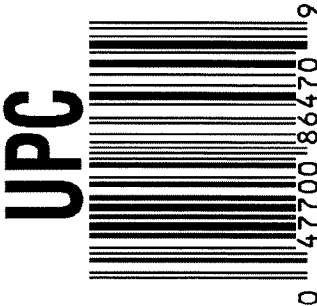
BM FORM

ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6863678



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6863678

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-10-09	SP
430	ASSEMBLE TO STOCK		6-10-09	SP
440	PROOF		6-10-09	SP
460	CHECK HEADSPACE	MAGNA FLUX	6-10-09	SP
470	DIS-ASSEMBLE ACTION		6-10-09	SP
472	SERIALIZE BOLT HANDLE		6-11-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR <u>(D)</u>	6/13/09	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6/16/09	RT
510	DRILL AND TAP SIGHT HOLES		6-11-09	SP
520	GOFF BLAST BBL / REC		6/16/09	KTU
540	APPLY COATINGS (BARREL ACTION)		6/24	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-05-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-05-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	6-25-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-10-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

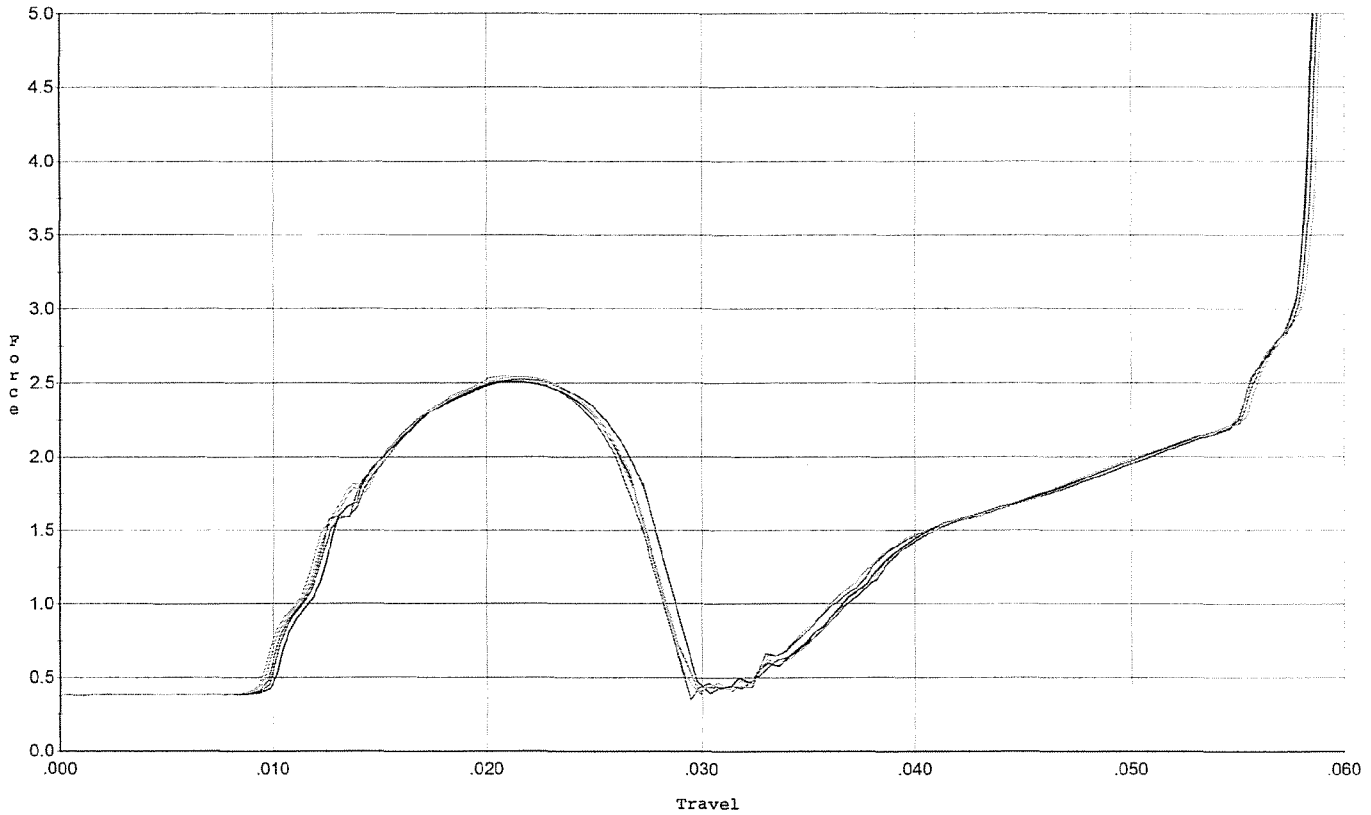
OP #	OPERATION NAME	BARBER - M24 0094530	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>4.2</u> <u>4.9</u> <u>4.9</u>	8/20/09	RB
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>6.9</u> <u>6.0</u> <u>6.0</u>	8/20/09	RB
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	8/20/09	RB
	J) ASSEMBLE STOCK			8-10-09	SPD.
	K) ASSEMBLE SWIVEL STUDS			8/20/09	RB
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				
	M) IRON SIGHT ALIGNMENT				
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				
640 & 650	FUNCTION TEST AND TARGET		PASS PASS FAIL FAIL	8-18-09	RB
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
660	INSPECT FOR LIVE AMMO			8-18-09	RB
670	FINAL INSPECTION A) HEADSPACE			8/20/09	RB
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.01</u> <u>2.63</u> <u>2.66</u> <u>2.61</u> <u>2.66</u>	8-22-09	RB
	C) FUNCTION			8/20/09	RB
690	PACK			8/20/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 8/7/09

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs. ini. +/- .50 lbs.



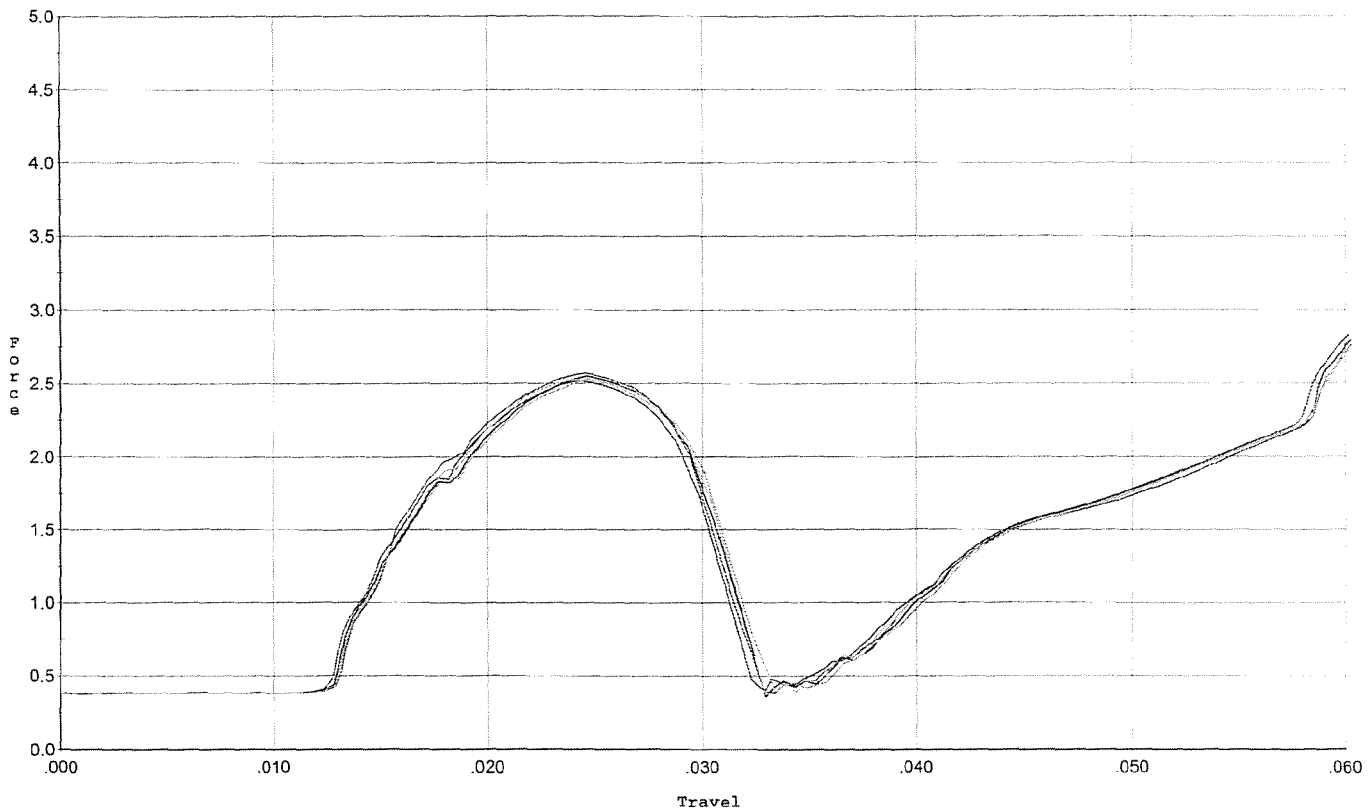
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.523	0.027	0.010	0.037	0.038		Set Trigger
2	2.506	0.027	0.010	0.037	0.037		Set Trigger
3	2.512	0.027	0.010	0.037	0.038		Set Trigger
4	2.545	0.027	0.010	0.037	0.038		Set Trigger
5	2.539	0.027	0.010	0.037	0.037		Set Trigger

Avg 2.52

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 8/7/09

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs. after 50 cycles +/- .50 lbs.



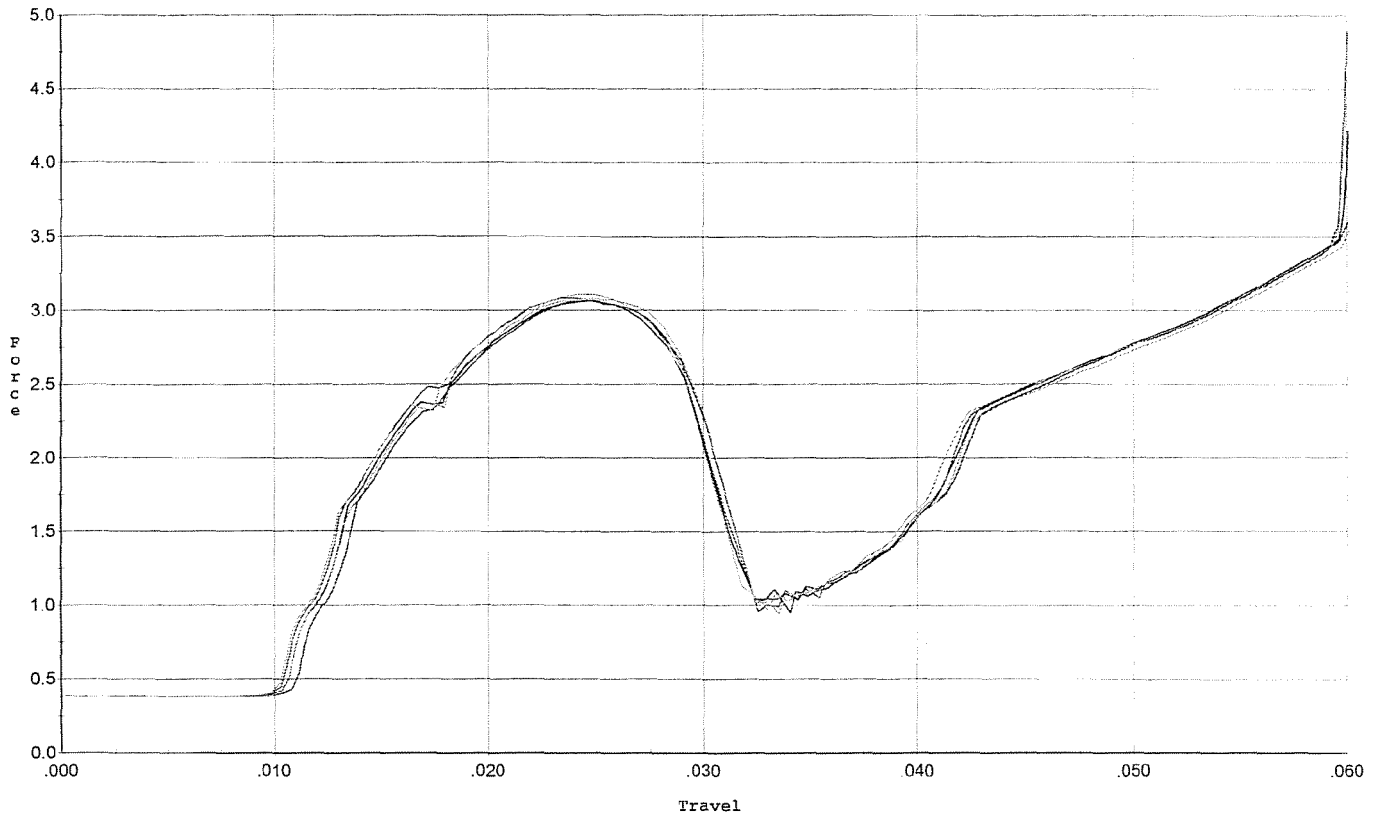
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.519	0.030	0.013	0.038	0.038		Set Trigger
2	2.550	0.031	0.013	0.038	0.040		Set Trigger
3	2.570	0.029	0.013	0.038	0.038		Set Trigger
4	2.531	0.030	0.013	0.038	0.039		Set Trigger
5	2.528	0.030	0.013	0.038	0.039		Set Trigger

Avg 2.54

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 8/7/09

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs. ini. +/- .75 lbs.



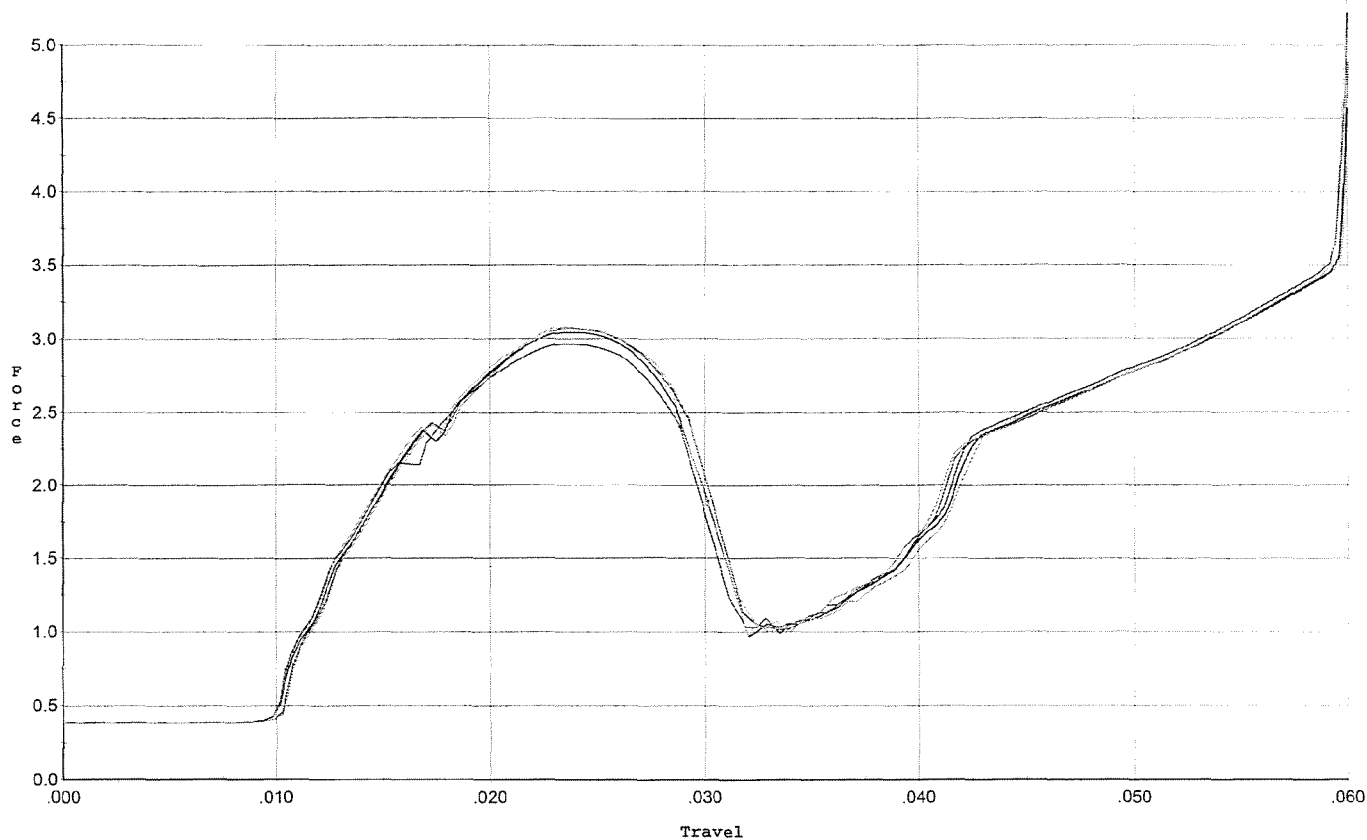
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.069	0.030	0.011	0.035	0.049		Set Trigger
2	3.066	0.029	0.011	0.035	0.048		Set Trigger
3	3.085	0.029	0.011	0.035	0.049		Set Trigger
4	3.107	0.029	0.010	0.035	0.049		Set Trigger
5	3.082	0.030	0.011	0.035	0.050		Set Trigger

Aug 3.08

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 8/7/09

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs. after 20 cycles +/- .75 lbs.



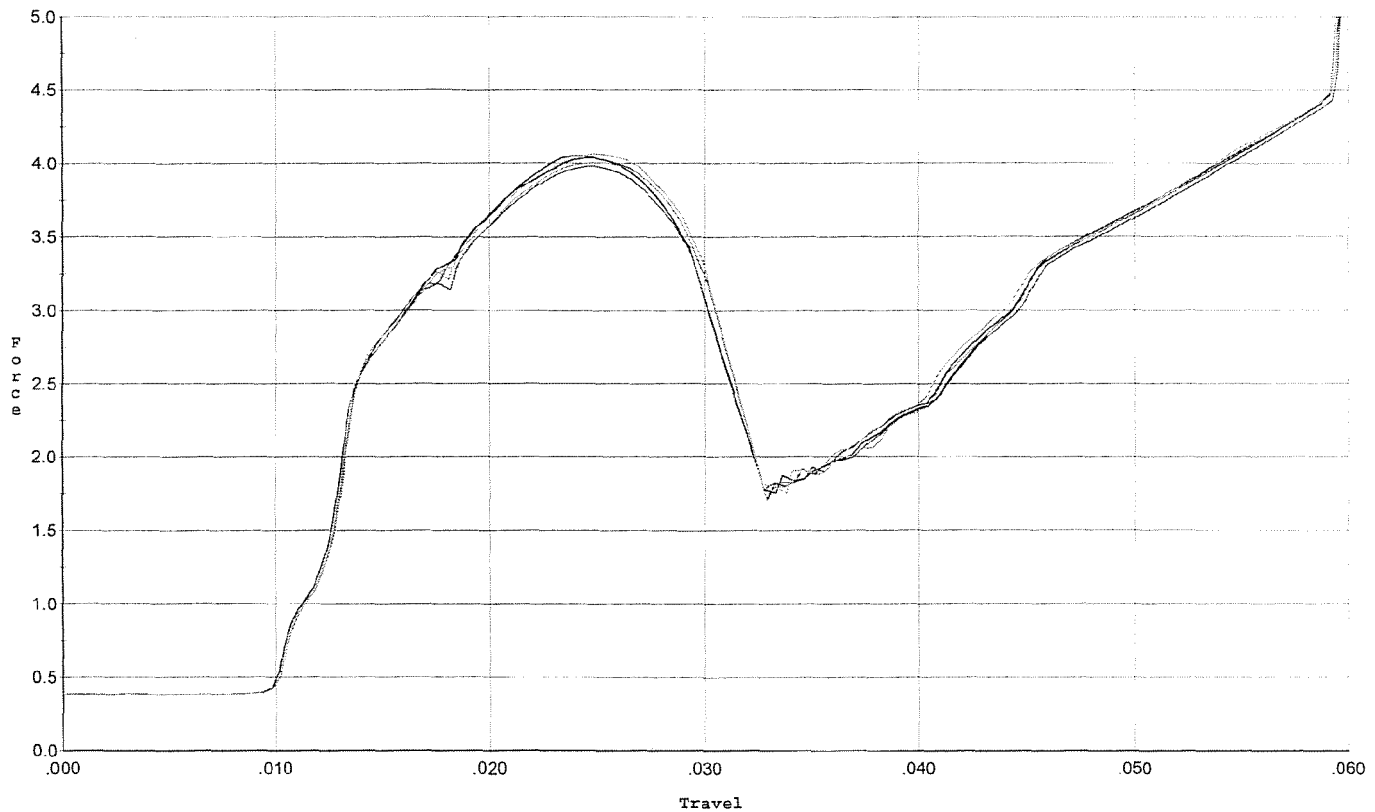
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.965	0.029	0.010	0.035	0.047		Set Trigger
2	3.042	0.030	0.010	0.035	0.049		Set Trigger
3	3.072	0.029	0.011	0.035	0.048		Set Trigger
4	3.080	0.030	0.010	0.035	0.050		Set Trigger
5	3.072	0.029	0.011	0.035	0.048		Set Trigger

Avg 3.04

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 8/7/09

Model: M/24
 Serial No: Form #F005
 Trigger: 4.0 lbs. ini. +/- 1.0 lbs.



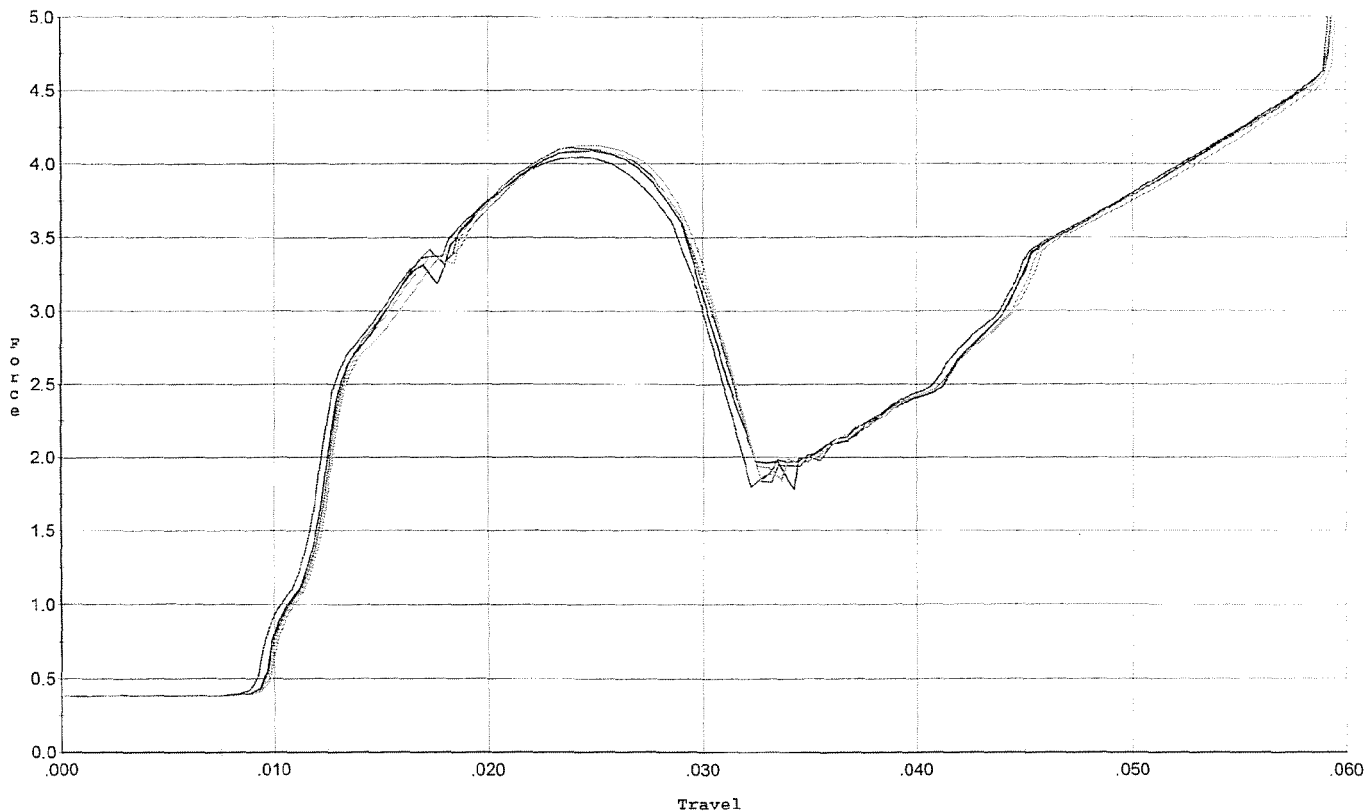
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.036	0.030	0.010	0.029	0.065		Set Trigger
2	4.052	0.029	0.010	0.029	0.063		Set Trigger
3	3.981	0.029	0.010	0.031	0.062		Set Trigger
4	4.064	0.030	0.010	0.029	0.065		Set Trigger
5	4.004	0.030	0.010	0.028	0.065		Set Trigger

Avg 4.02

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 8/7/09

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. after 20 cycles +/- 1.0 lbs.



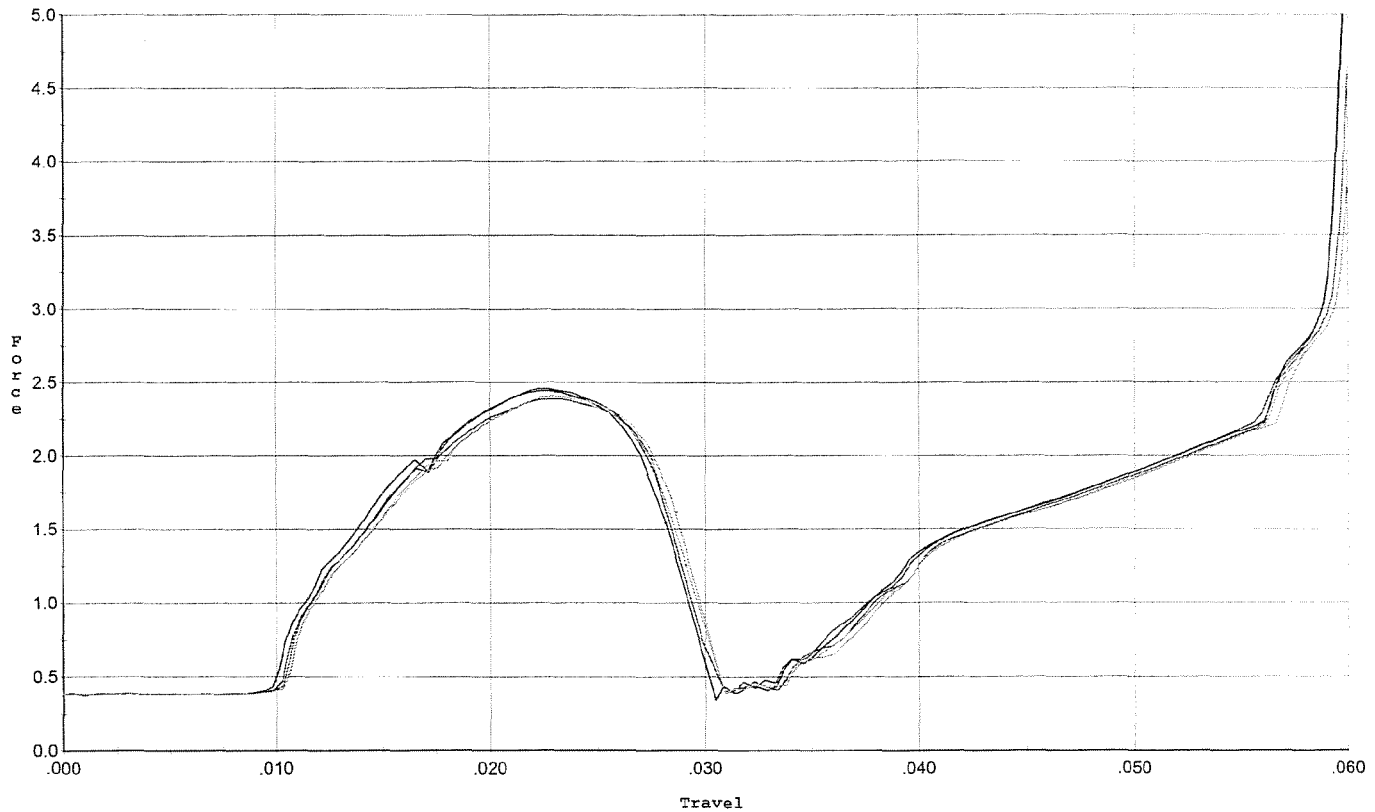
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.048	0.030	0.009	0.030	0.066		Set Trigger
2	4.088	0.029	0.010	0.029	0.065		Set Trigger
3	4.106	0.030	0.010	0.028	0.068		Set Trigger
4	4.125	0.030	0.010	0.028	0.067		Set Trigger
5	4.091	0.030	0.010	0.028	0.067		Set Trigger

Avg 4.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 8/7/09

Model: M/24
 Serial No: Form #F005
 Trigger: reset to 2.5 lbs. +/- .50 lbs. for final test



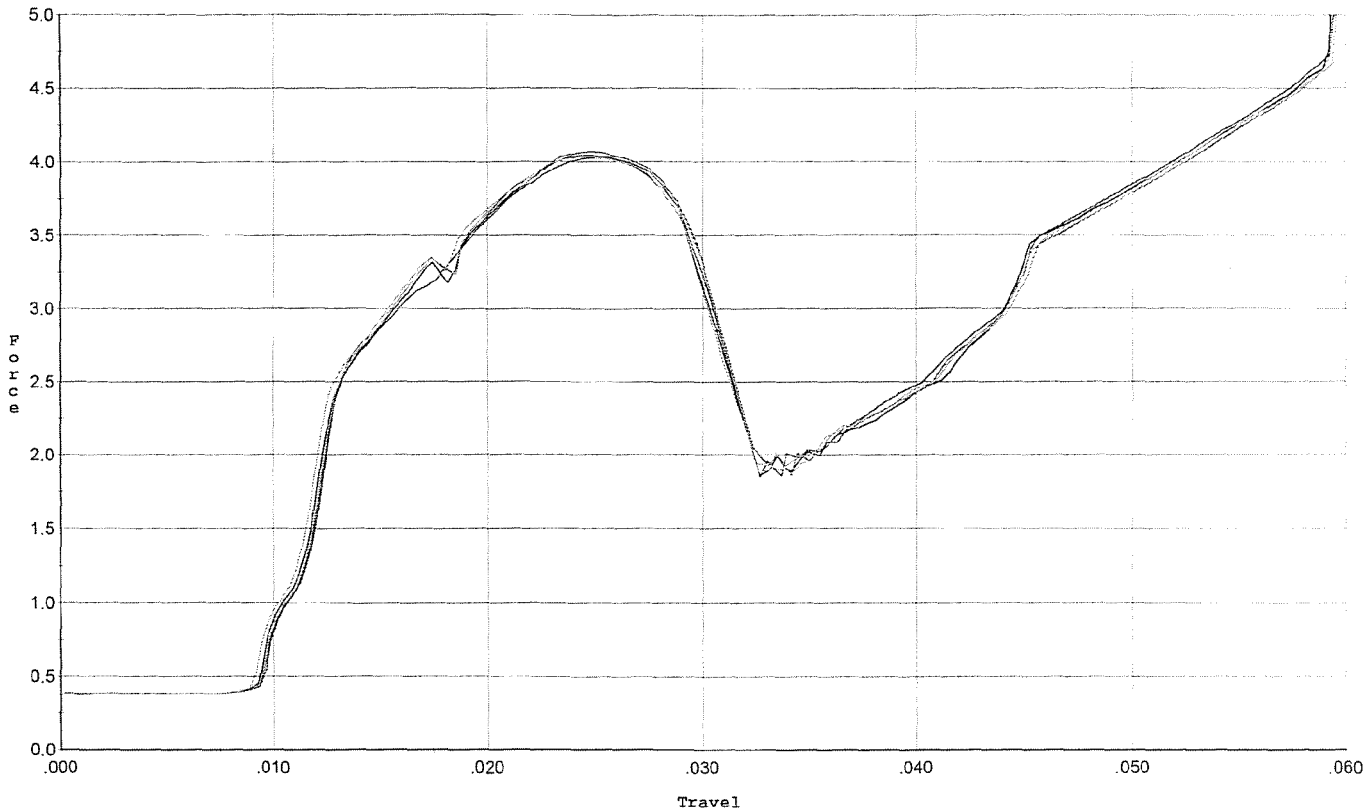
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.456	0.028	0.010	0.037	0.037		Set Trigger
2	2.442	0.028	0.010	0.038	0.038		Set Trigger
3	2.386	0.029	0.011	0.038	0.038		Set Trigger
4	2.402	0.029	0.011	0.038	0.038		Set Trigger
5	2.407	0.028	0.011	0.038	0.037		Set Trigger

Avg 2.41

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R.P. 8/7/09

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.028	0.030	0.010	0.028	0.057		Set Trigger
2	4.043	0.031	0.010	0.028	0.058		Set Trigger
3	4.069	0.030	0.010	0.028	0.066		Set Trigger
4	4.034	0.030	0.010	0.028	0.067		Set Trigger
5	4.034	0.029	0.009	0.029	0.065		Set Trigger

Aug 4.04